

Date: Tuesday, 19/08/2008 4:05:23 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001-Dart Helicopters Services		Drawing Name	: CABIN FLOOR PROTECTOR		
Job Number	: 41468		Part Number	: D35741		
Estimate Number	: 12660		Drawing Number	: D3574 REV.A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 19/08/2008	S.O. No. :	Drawing Revision	: A		
Prsh Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 05/09/2008	Qty:	4 Um: Each
Previous Run	: 40644					
Written By	:					
Checked & Approved By	: <u>JUL 08.879</u>					
Comment	: Est Rev :A New Issue 07-01-22 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
Comment: Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s) lexan sheet Batch: <u>109455</u> <u>FB 8-10-1</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev: <u>A</u> <u>FB 8-10-1</u> Prog Rev: <u>A</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>FB 8-10-1</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>M</u> <u>/</u> <u>08/10/01</u> <u>(4)</u>		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Deburr if necessary. <u>SAD</u> <u>08/10/07</u> <u>(4)</u>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:05:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 41468

Part Number: D35741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



S 08/10/08 (X)

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

PPP 41310

8/10/08

SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/08 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CMF 08-10-07

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	411468
Description: Cabin Floor Protector	Part Number:	D3574-1
Inspection Dwg: D3574 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	*		Tape	
7.37	+/-0.030	7.37	*			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
25.87	+/-0.030	25.87	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			
53.51	+/-0.030	53.51	*			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	*			
10.75	+/-0.030	10.75	*			
14.75	+/-0.030	14.75	*			
25.50	+/-0.030	25.50	*			
25.75	+/-0.030	25.75	*			
26.00	+/-0.030	26.00	*			
32.87	+/-0.030	32.87	*			
38.81	+/-0.030	38.81	*			
45.00	+/-0.030	45.00	*			
58.38	+/-0.030	58.38	*			
61.25	+/-0.030	61.25	*			
64.13	+/-0.030	64.13	*			
64.63	+/-0.030	64.63	*			
7.50	+/-0.030	7.50	*			
9.50	+/-0.030	9.50	*			
10.38	+/-0.030	10.38	*			
10.88	+/-0.030	10.88	*			
14.50	+/-0.030	14.50	*			
16.56	+/-0.030	16.56	*		✓	

DART AEROSPACE LTD	Work Order:	41468
Description: Cabin Floor Protector	Part Number:	D3574-1
Inspection Dwg: D3574 Rev: A		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

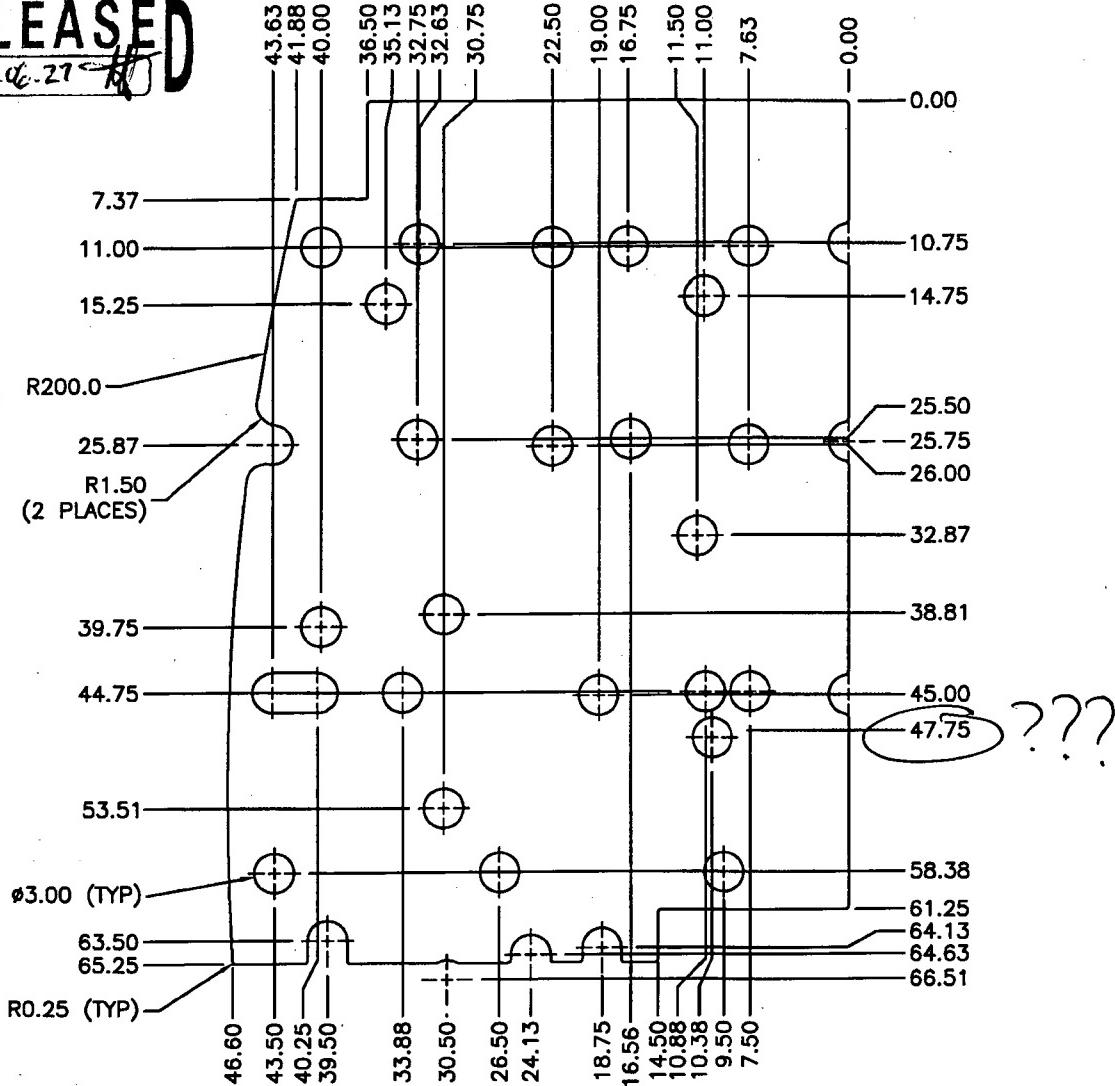
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.75	+/-0.030	18.75	*			Top
24.13	+/-0.030	24.13	X			
26.50	+/-0.030	26.50	X			
30.50	+/-0.030	30.50	X			
33.88	+/-0.030	33.88	X			
39.50	+/-0.030	39.50	X			
40.25	+/-0.030	40.25	X			
43.50	+/-0.030	43.50	X			
46.60	+/-0.030	46.60	X			
7.63	+/-0.030	7.63	X			
11.00	+/-0.030	11.00	X			
11.50	+/-0.030	11.50	X			
16.75	+/-0.030	16.75	X			
19.00	+/-0.030	19.00	X			
22.50	+/-0.030	22.50	X			
30.75	+/-0.030	30.75	X			
32.63	+/-0.030	32.63	X			
32.75	+/-0.030	32.75	X			
35.13	+/-0.030	35.13	X			
36.50	+/-0.030	36.50	X			
40.00	+/-0.030	40.00	X			
41.88	+/-0.030	41.88	X			V
43.63	+/-0.030	43.63	X			

Measured by:	HB	Audited by:		Prototype Approval:	N/A
Date:	8-90-1	Date:	08.10.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	DA

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07.06.27 *H***D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

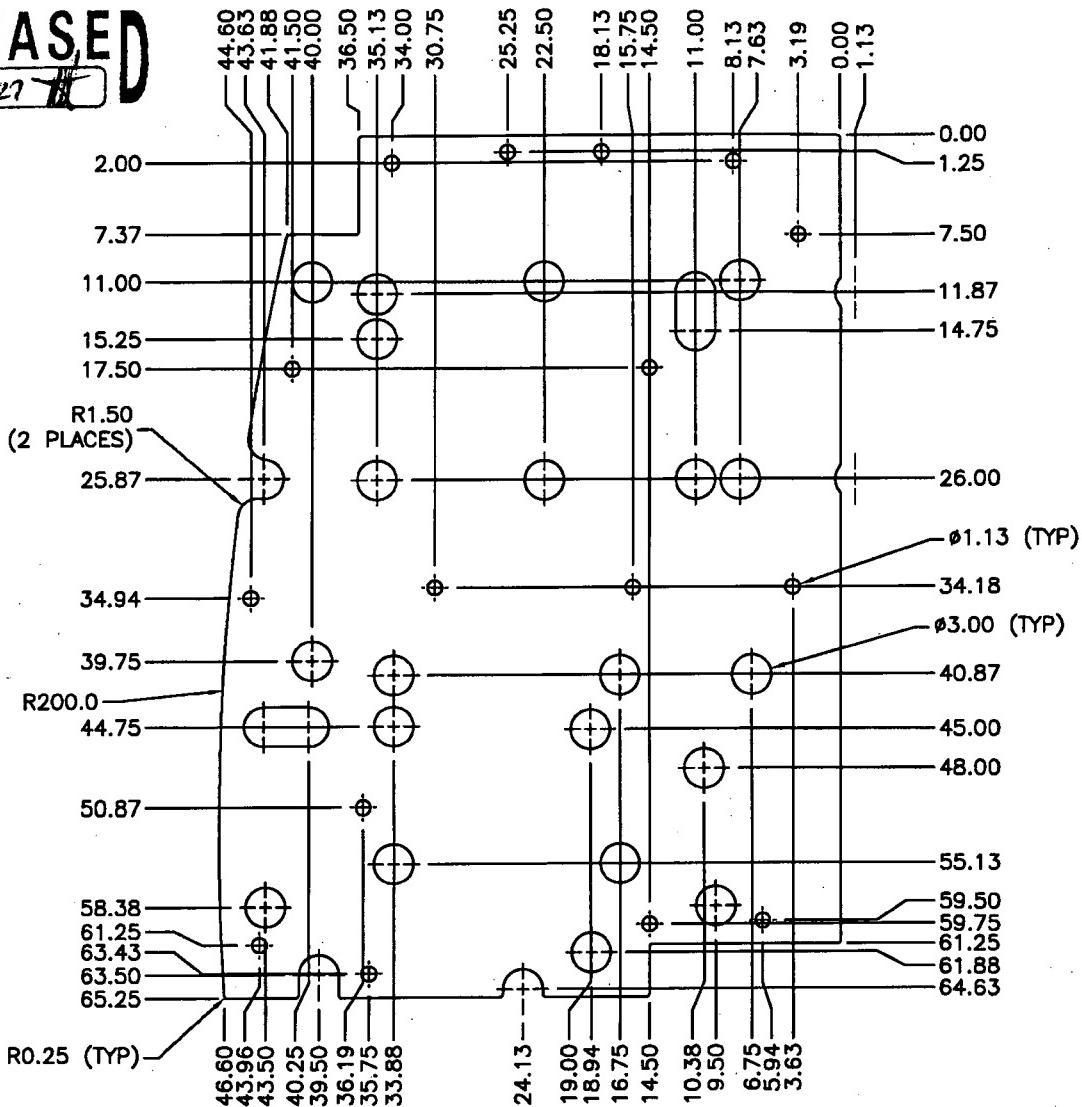
- MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) SHOP COPY RETURN TO ENGINEERING
 - FINISH: NONE
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER UNCONTROLLED COPY SUBJECT TO AMENDMENT
 - ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
 - CHECK PER TEMPLATE DT8961
- WITHOUT NOTICE
WORK ORDER
NO. 41408

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CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3574	REV. A SHEET 2 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27D3574-3 CABIN FLOOR PROTECTORNOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK TO TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

SHOP COPY

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

INK WITH MARKER

WORK ORDER

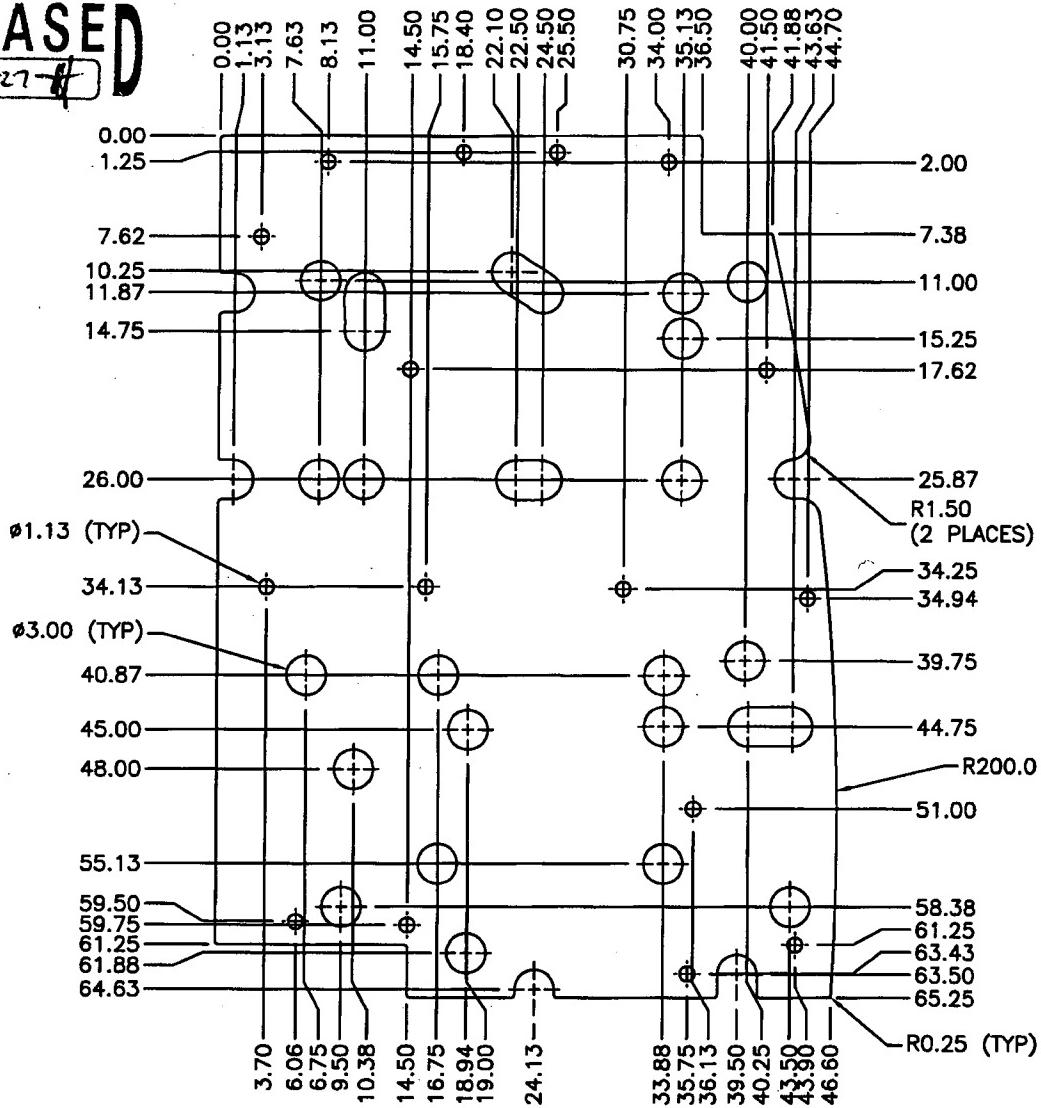
NO. U14468

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CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3574	REV. A SHEET 3 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
67.46 27-4**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

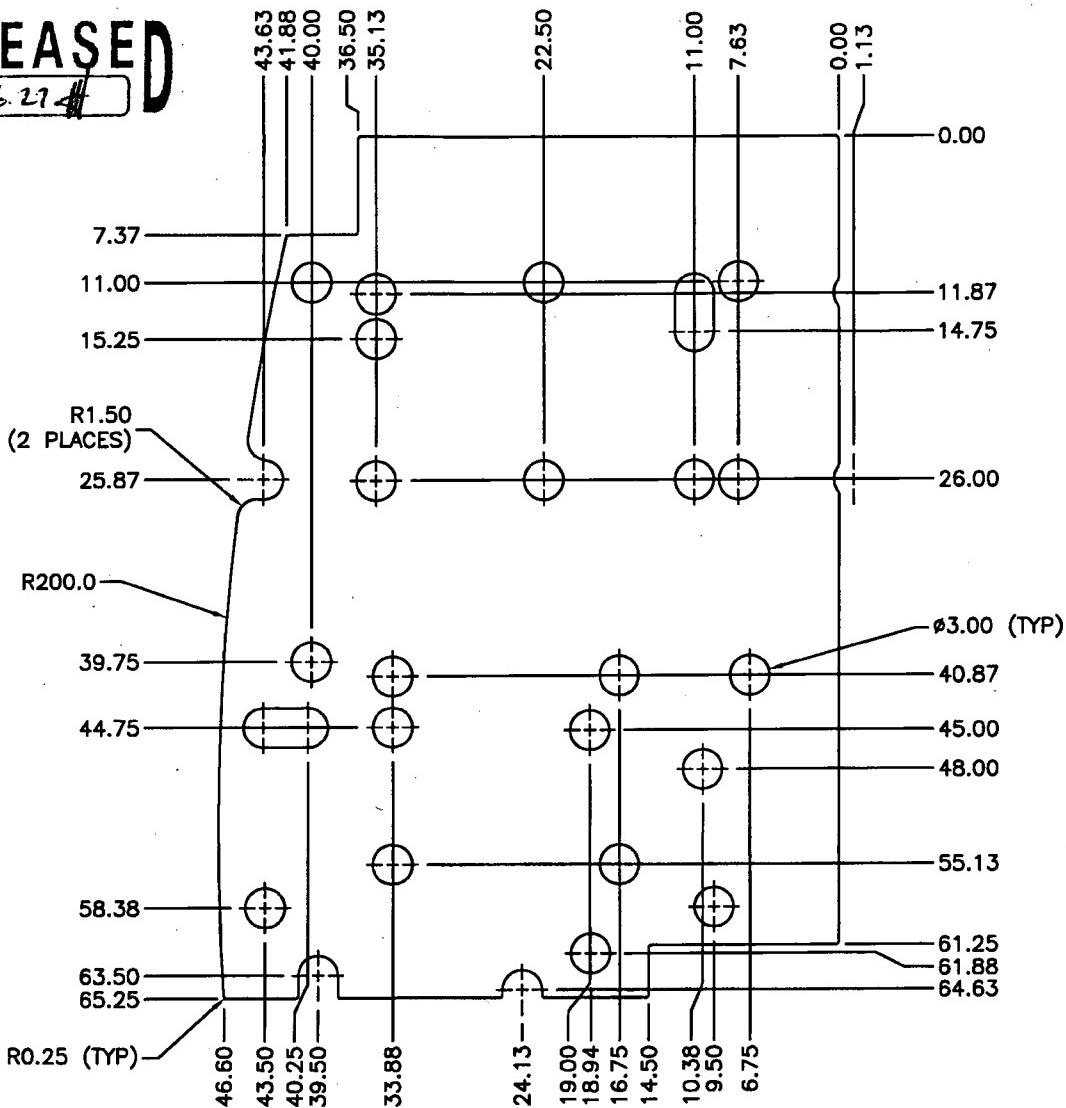
- MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK^{SHOT} RETURN TO ENGINEERING
- FINISH: NONE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK UNCONTROLLED COPY SUBJECT TO AMENDMENT
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- CHECK PER TEMPLATE DT8963 WITHOUT NOTICE WORK ORDER NO. *41468*

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CHECKED <i>CE</i>	APPROVED <i>HH</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.21**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

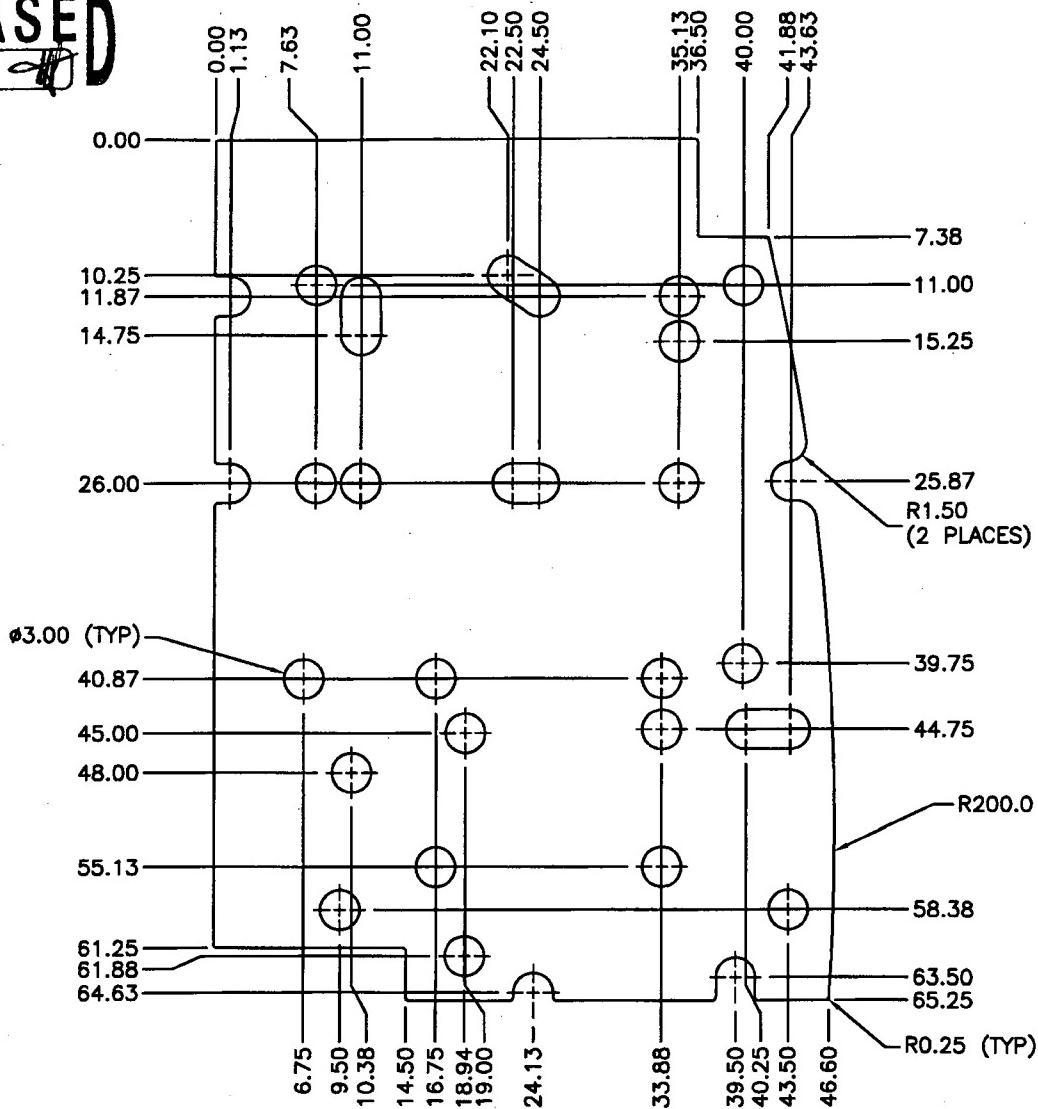
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) SHOP COPY
- 2) FINISH: NONE RETURN TO ENGINEERING
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER COPY ON SMOOTH SIDE OF PART SUBJECT TO AMENDMENT
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964 WITHOUT NOTICE WORK ORDER NO. U1468

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CHECKED <i>CE</i>	APPROVED <i>dh</i>	DRAWING NO.	REV. A
DATE 07.06.08		D3574	SHEET 5 OF 5
		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27 *dh***D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 ~~THICK~~ COPY
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO
ENGINEERING
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK
ON SMOOTH SIDE OF PART UNCONTROLLED COPY SUBJECT TO ENDMENT
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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